

Date: Thursday, 11/12/2008 10:10:08 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DECK PLATE KIT
Job Number :	44006		
Estimate Number :	11233		
P.O. Number :		Part Number :	D350616015
This Issue :	11/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D350-616 REV E
First Issue :	//	Project Number :	N/A
Previous Run :	43280	Drawing Revision :	E
		Material :	
		Due Date :	22/12/2008
Written By :		Qty:	3
Checked & Approved By :	JLD 08.12.11	Um:	Each
Comment :	Est Rev:C Removed Manufacturing 05-12-05 JLM Est Rev:D Add D3494-1 05-12-05 JLM Est rev E added parts per NCR 08-041 08.04.30 EC verified by: DD Est Rev:F 08-12-10 rev.E as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



for CL 08/12/22



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D350-616-015 CHG002

8 09/01/09

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2344	Litter Deck Plate, 350
-----	-------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2344 Deck Plate (Aft) *B38810*

50

4.0	D2348	Wearplate
-----	-------	-----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2348 Wear Plate (Key Way) *B37578*

9/1/08

3x

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:10:08 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 44006

Part Number: D350616015

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D2353	Stiffener
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2353 Stiffener B39639

6.0	D2364	Deck Plate, Fwd 350 Litt
-----	-------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2364 Deck Plate (Fwd) 41423

7.0	D2365	Wearplate
-----	-------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2365 Wear Plate (Pip Pin) B41424

8.0	D23691	Deck Plate Locator Brackets
-----	--------	-----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-1 Locator Plate 41425

9.0	D23693	Deck Plate Locator Brackets
-----	--------	-----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-3 Locator Plate B39640

10.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

10 AN960JD10 Washer M109061

9/1/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 44006

Part Number: D350616015

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0	MS20426AD45	Rivet
------	-------------	-------



Comment: Qty.: 25.0000 Each(s)/Unit Total : 75.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-5 Rivet M4007

12.0	MS20426AD46	Rivet
------	-------------	-------



Comment: Qty.: 25.0000 Each(s)/Unit Total : 75.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-6 Rivet M105144

13.0	MS20426AD57	Rivet
------	-------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-7 Rivet M4601

14.0	MS20426AD58	Rivet
------	-------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-8 Rivet M4533

15.0	MS20601AD4W2	Rivet
------	--------------	-------



Comment: Qty.: 15.0000 Each(s)/Unit Total : 45.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 MS20601AD4W2 Blind Rivet M108246

29
M110322

9/1/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: DECK PLATE KIT

Job Number: 44006

Part Number: D350616015

Job Number:



Seq. #: Machine Or Operation: Description :

16.0 MS20601AD4W3 Rivet



Comment: Qty.: 30.0000 Each(s)/Unit Total : 90.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

30 MS20601AD4W3 Blind Rivet M102927

M107823

SP

17.0 MS21042L3



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L3 Nut (or -3) M108816

SP

18.0 MS24693C48 Screw



Comment: Qty.: 22.0000 Each(s)/Unit Total : 66.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

22 MS24693-C48 Screw (or -48) M104215

SP

19.0 MS24693C273 Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS24693-C273Screw (or -273) M108246

SP

20.0 D34941 Stub Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

STUB COVER

Batch: 41956

9110

3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 44006

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS35207264

Screw



3x

Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

batch: M107959

9/1/18

sq

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 09/01/09 @

23.0

PACKAGING 1

PACKAGING RESOURCE #1



3x

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-616-015

Location: 31

PPP Rev: C

9/1/19

sq

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/12

Job Completion



MF-09-01-09.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370	LITTER ASSEMBLY
1			D2493	PATIENT STOP
	1		D3179-041	LITTER TIE DOWN (NON-LOCKING)
		1	D3494-1	STUB COVER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (or CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (or CR9162-4-3)
		6	MS21042L3	NUT (or MS21042-3)
		6	MS24693-C273	SCREW (or MS24693-273)
		22	MS24693-C48	SCREW (or MS24693-48)
		4	MS35207-264	SCREW
		10	NAS1149D0363J	WASHER (or AN960JD10)

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DAO # 01-O-01

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BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 08.11.07
CERT. NO.: SH96-10
ISSUE NO.: 2

E	MAKE DSI 9310 STANDARD; D3179-041 REPLACES D2350	RF	08.11.07
D	ADD D3494-1 STUB COVER	MB	06.01.19
C	ADD DSI 9112/9117/9130/9236/9310	MB	06.01.10
B	ADD VIEW OF D2493 TO SHEET 9	BW	96.01.09
A	NEW ISSUE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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GENERAL NOTES:

1. COMPATIBILITY

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE RESPONSIBILITY OF THE INSTALLER. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

2. WORKMANSHIP

UNLESS OTHERWISE STATED, ALL WORKMANSHIP SHOULD BE TO THE STANDARD SET BY THE AIRCRAFT MAINTENANCE MANUAL.

3. INSTALLATION INSTRUCTIONS

THIS DRAWING IS TO BE USED IN CONJUNCTION WITH INSTALLATION INSTRUCTIONS IIN-D350-616.

4. CONTINUING AIRWORTHINESS

THIS INSTALLATION SHOULD BE MAINTAINED IN ACCORDANCE WITH MAINTENANCE MANUAL SUPPLEMENT MMS-D350-616.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-616-011	31.3 lb	17.3 in	541.5 in-lb	63.8 in	1996.9 in-lb
Full Litter Kit	14.19 kg	0.44 m	6.24 m-kg	1.62 m	22.99 m-kg
D350-616-013	6.3 lb	15.4 in	97.0 in-lb	52.0 in	327.6 in-lb
Deck Plate & Tie Down	2.86 kg	0.39 m	1.12 m-kg	1.32 m	3.78 m-kg
D350-616-015	2.8 lb	15.6 in	43.7 in-lb	53.0 in	148.4 in-lb
Deck Plate Kit	1.27 kg	0.40 m	0.51 m-kg	1.35 m	1.71 m-kg
Person Approximate CG	lb	18 in	in-lb	72 in	in-lb
	kg	0.46 m	m-kg	1.88 m	m-kg

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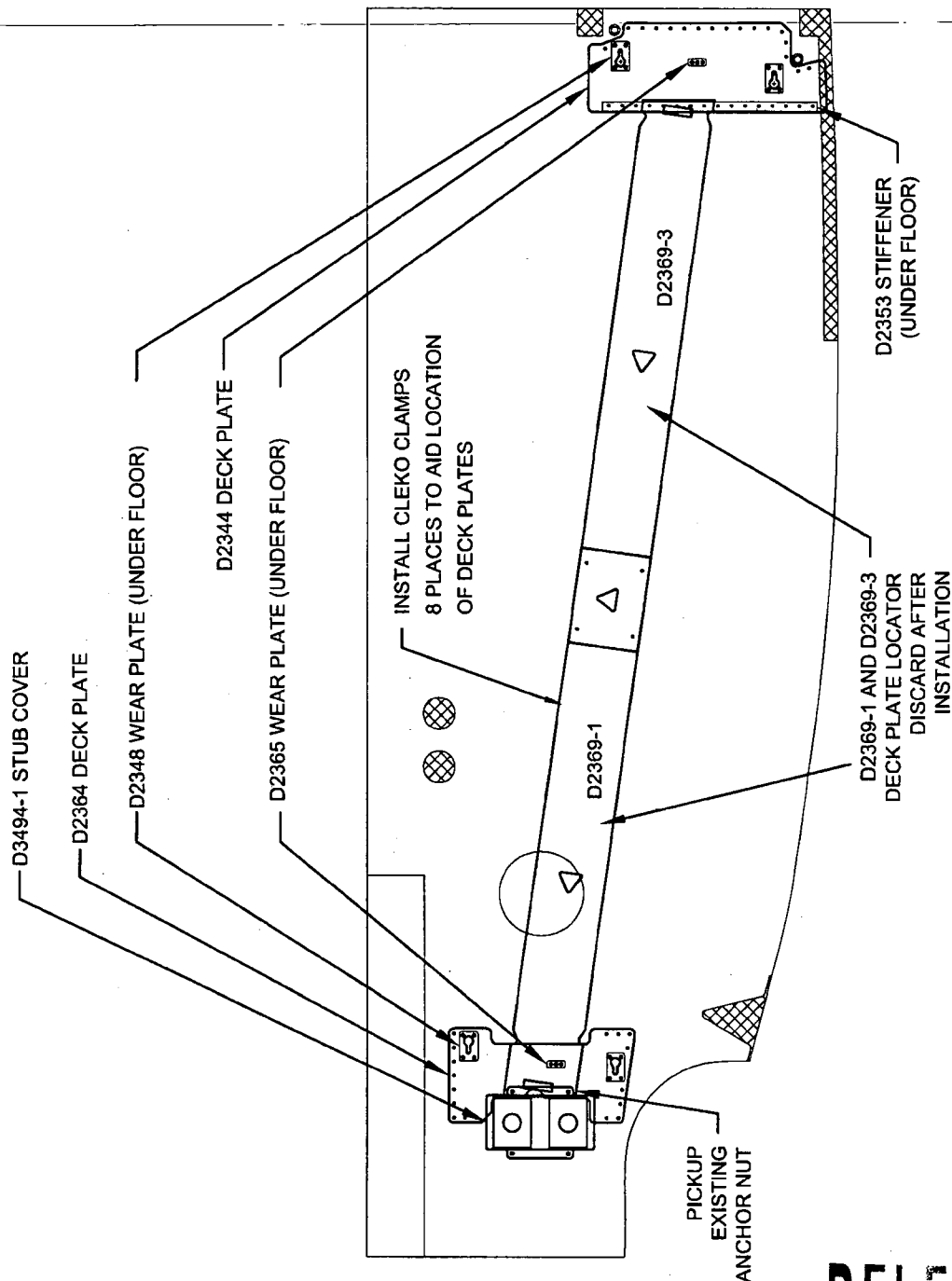


FIGURE 1

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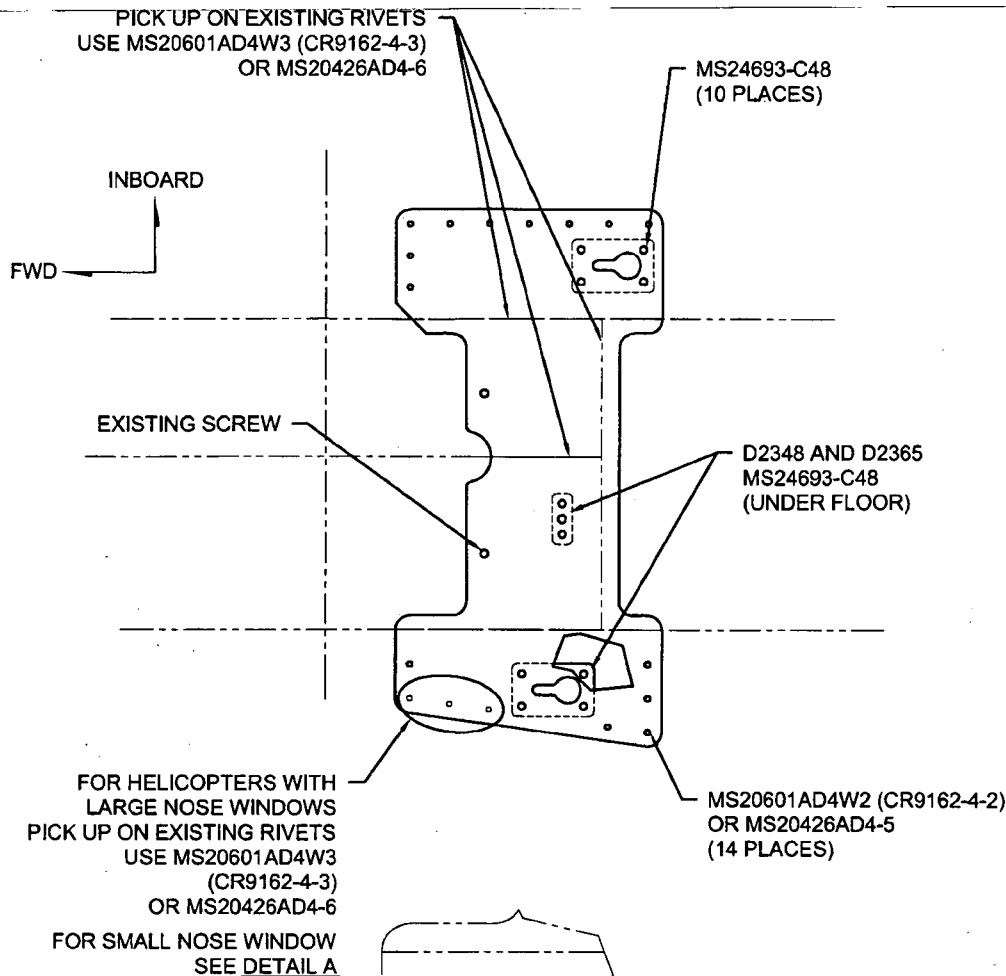
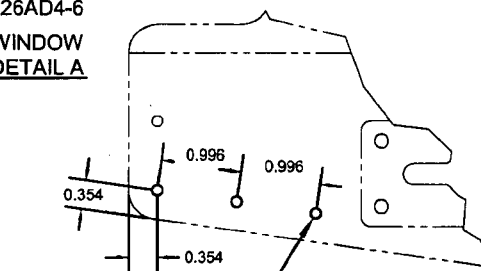


FIGURE 2



DRILL AND INSTALL
USE MS20601AD4W2
(CR9162-4-2)
OR MS20426AD4-5

DETAIL A

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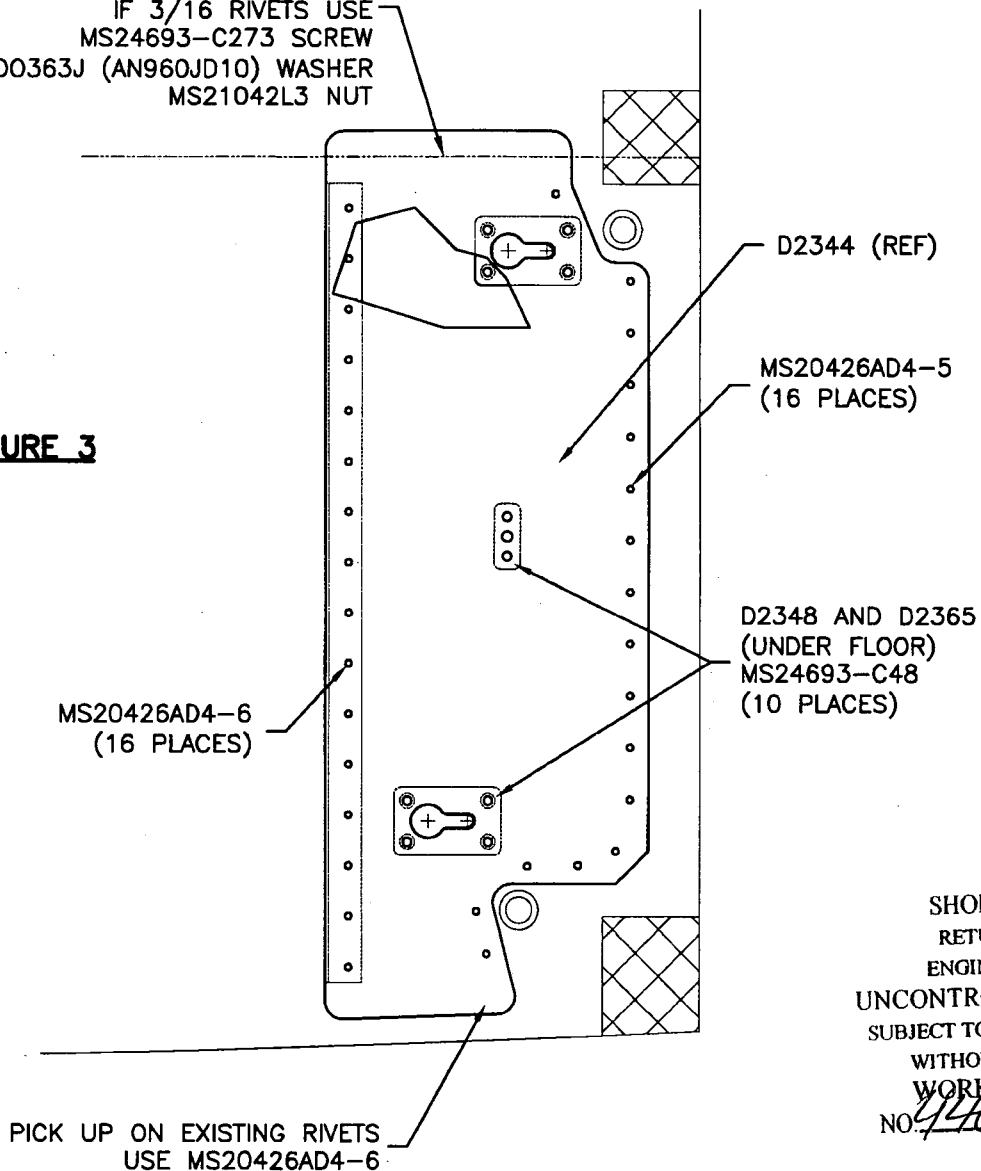
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PICK UP ON EXISTING RIVETS
 IF 5/16 RIVETS USE
 MS20426AD5-7/MS20426AD5-8
 IF 3/16 RIVETS USE
 MS24693-C273 SCREW
 NAS1149D0363J (AN960JD10) WASHER
 MS21042L3 NUT

FIGURE 3



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FIGURE 4: LITTER TIE DOWN INSTALLATION

D3494-1 STUB COVER
PICK UP ON EXISTING INSERTS:
USE EXISTING SCREWS OR

MS35207-264 SCREWS (4)
AND NAS1149D0363J (AN960JD10)
WASHERS (4)

D3179-041
LITTER TIE DOWN
(NON-LOCKING)

D2360
LITTER TIE DOWN
(LOCKING)

ACCEPTABLE TO TRIM
D3179-041 AS REQUIRED
FOR FIT AS LONG AS
A MINIMUM EDGE DISTANCE
OF 0.250" IS MAINTAINED
FROM THE EDGE OF ALL
HOLES AND SLOTS.
TOUCH UP WITH PRIMER &
PAINT IN ACCORDANCE WITH
AIRCRAFT MAINTENANCE
MANUAL PRIOR TO FINAL
INSTALL.

INBOARD

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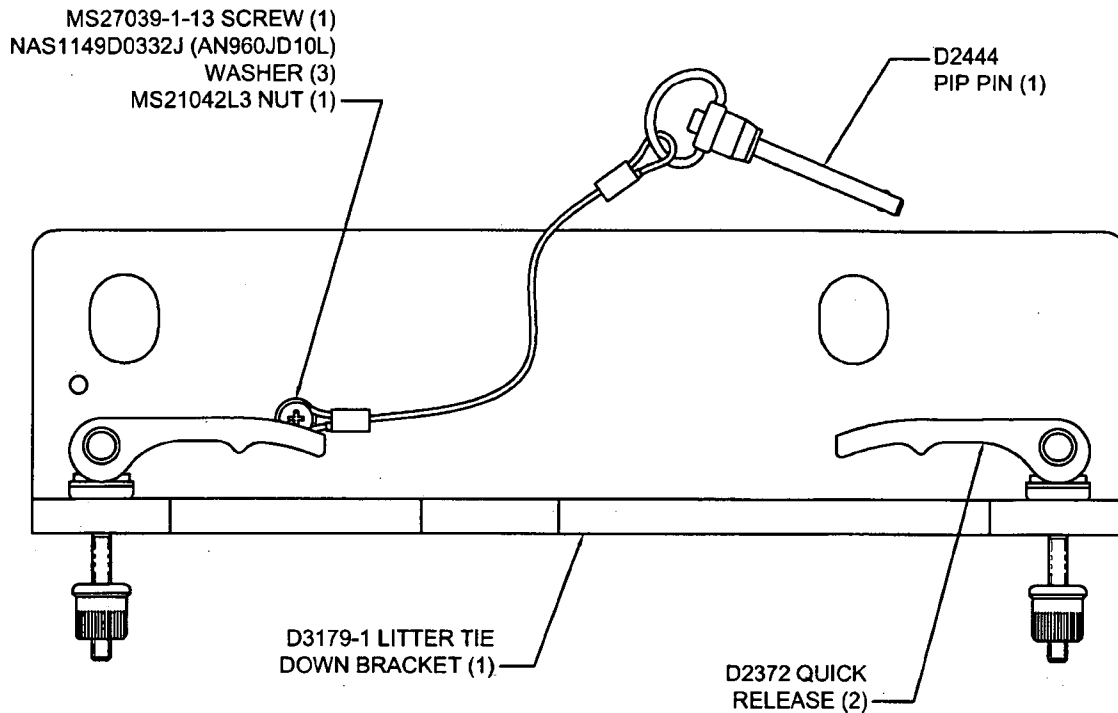


FIGURE 5: D3179-041 FWD LITTER TIE DOWN BRACKET
(PART REFERENCE)

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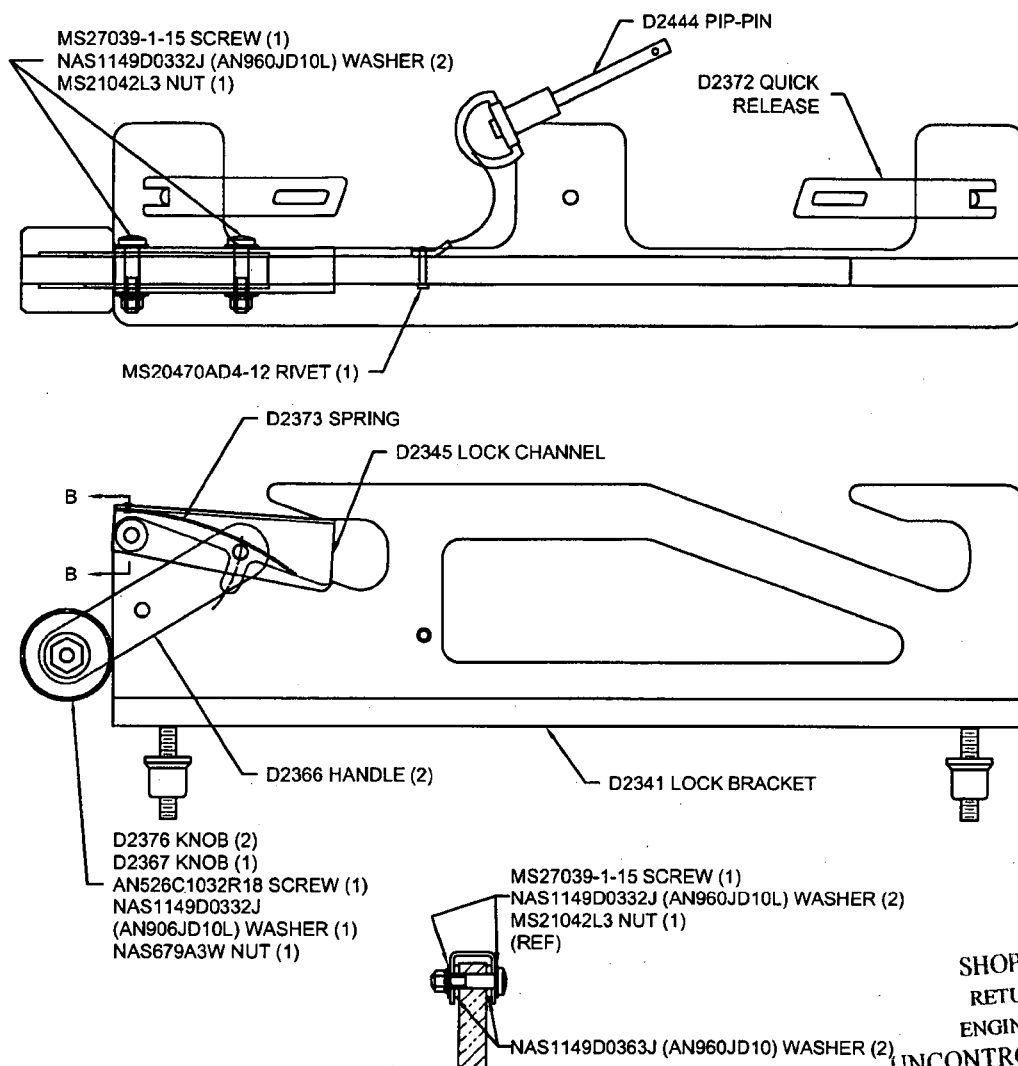
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SECTION B-B

FIGURE 6: D2360 TIE DOWN ASSEMBLY
(PART REFERENCE)

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MFG. APPR.	N/A	D350-616	SHEET 8 OF 12
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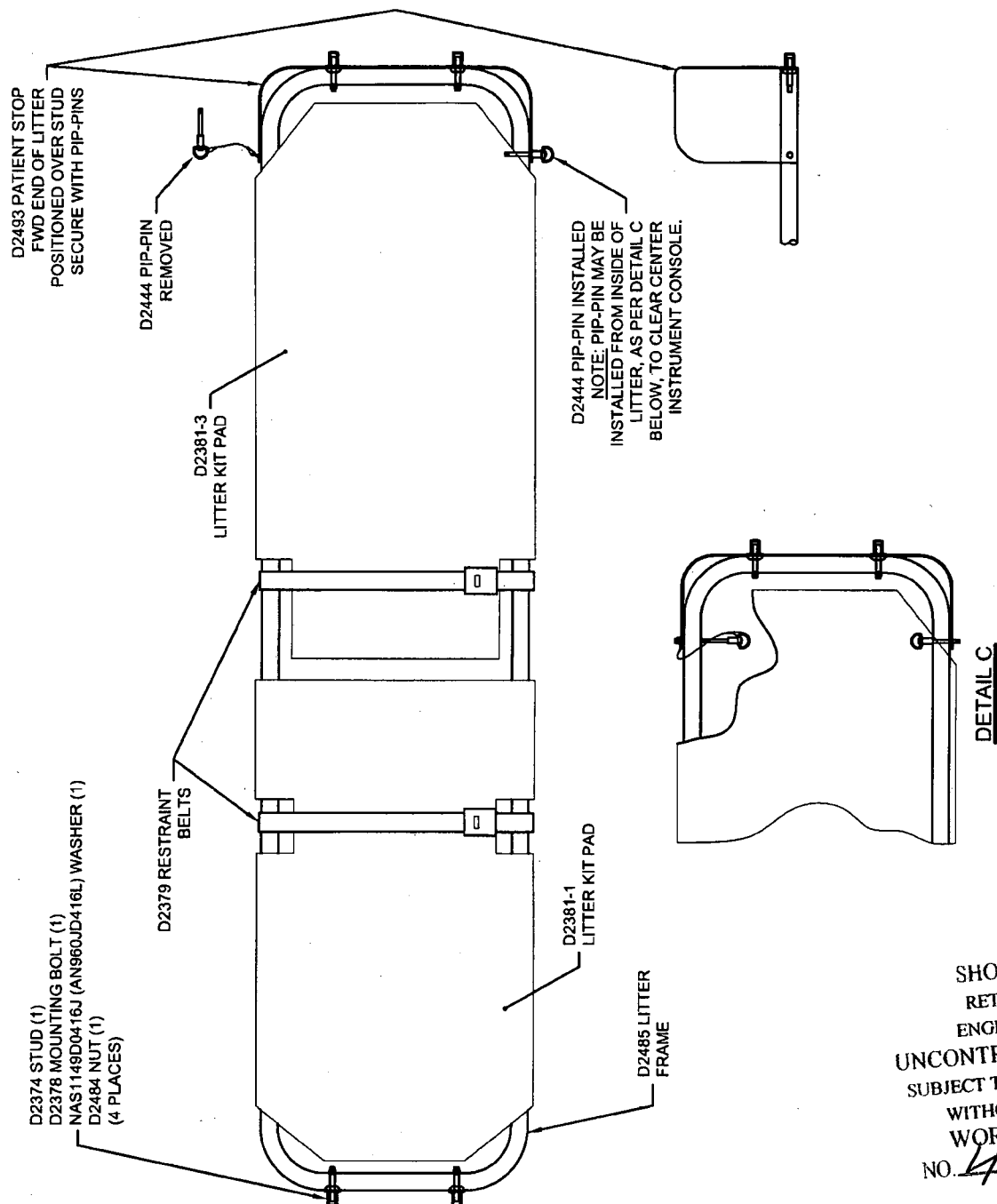


FIGURE 7: D2370 LITTER ASSEMBLY
(PART REFERENCE)

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.11.07

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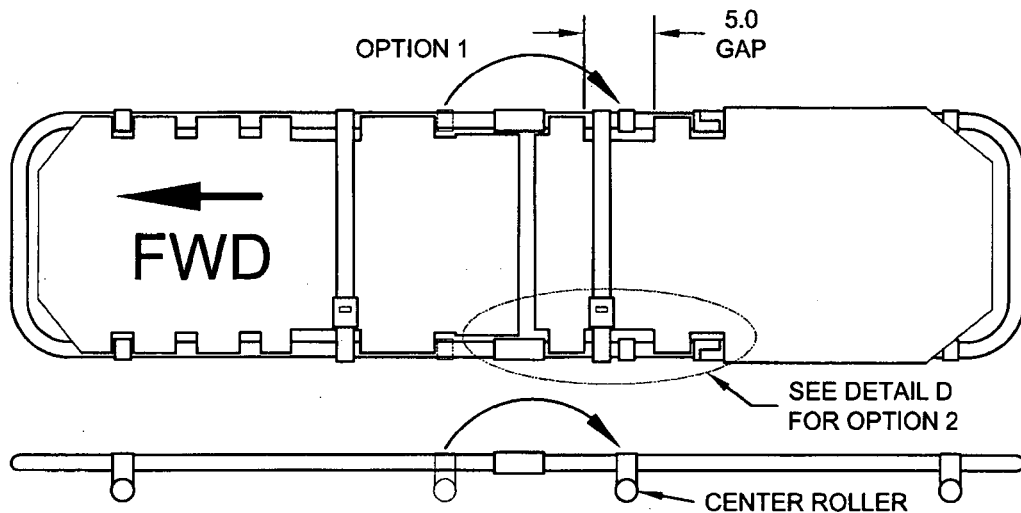
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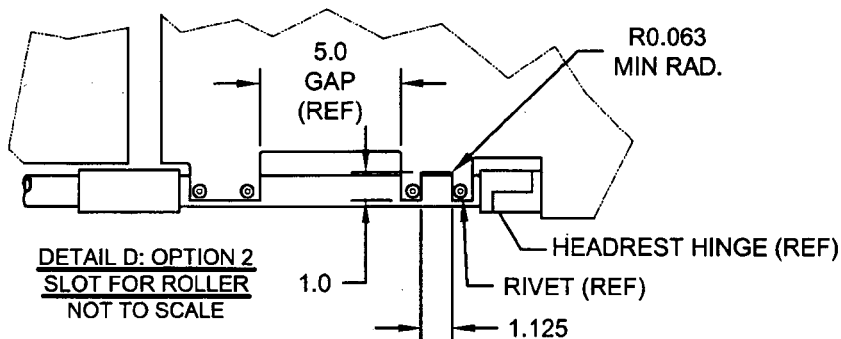
COMPATIBILITY WITH ENERGY ATTENUATING SEATS

TO FACILITATE INSTALLATION OF THE D350-616-011 LITTER KIT WITH THE SEAT RAILS OF THE ENERGY ATTENUATING SEATS, IT IS ACCEPTABLE TO MOVE THE CENTER ROLLER SUPPORT AFT AS INDICATED:

OPTION 1. MOVE THE CENTER ROLLER ANYWHERE WITHIN THE 5.0" WIDE BELT GAP SHOWN BELOW.



OPTION 2. FOR COMPATIBILITY WITH EXTENDED SEAT RAILS, IT IS ALSO ACCEPTABLE TO CUT A 1.125" WIDE x 1.00" DEEP SLOT FOR INSTALLATION OF THE CENTER ROLLER JUST BEFORE THE HEADREST HINGE AS SHOWN BELOW. ENSURE THE SLOT IS CENTERED BETWEEN THE RIVETS AND LEAVES MAX. EDGE DISTANCE POSSIBLE.



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FIGURE 8: CENTER ROLLER RE-LOCATION

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D. SHEPHERD (DE # 02)

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COMPATIBILITY WITH SLIDING DOORS

AIRCRAFT EQUIPPED WITH A SLIDING DOOR CAN BE MODIFIED AS FOLLOWS TO BE COMPATIBLE WITH D350-616-011 LITTER KIT.

- (1) TRIM D2344 DECK PLATE TO WITHIN 0.05" OF THE DOOR RAIL AS SHOWN IN FIGURES 9 & 10. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
- (2) DRILL FOUR 0.128" DIAMETER HOLES IN D2344 DECK PLATE AS SHOWN IN FIGURE 10. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
ATTACH D2344 DECK PLATE PER IIN-D350-616 REV. A. IN THE FOUR DRILLED HOLES, FASTEN TO AIRCRAFT FLOOR SKIN WITH AN ADDITIONAL FOUR MS20426AD4-5 BLIND RIVETS.
- (3) TRIM FAIRING AS SHOWN IN FIGURE 10.

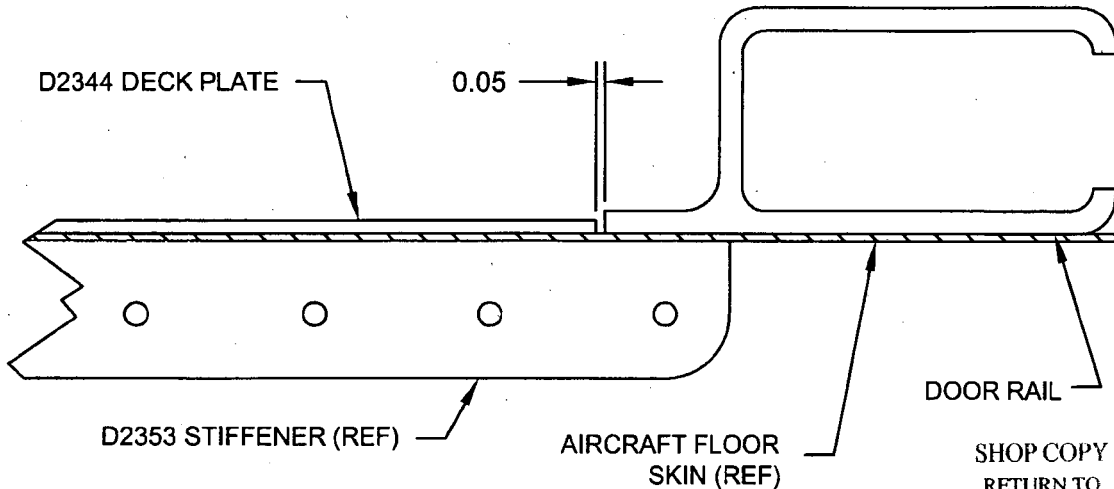


FIGURE 9
VIEW LOOKING AFT

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COMPATIBILITY WITH SLIDING DOORS

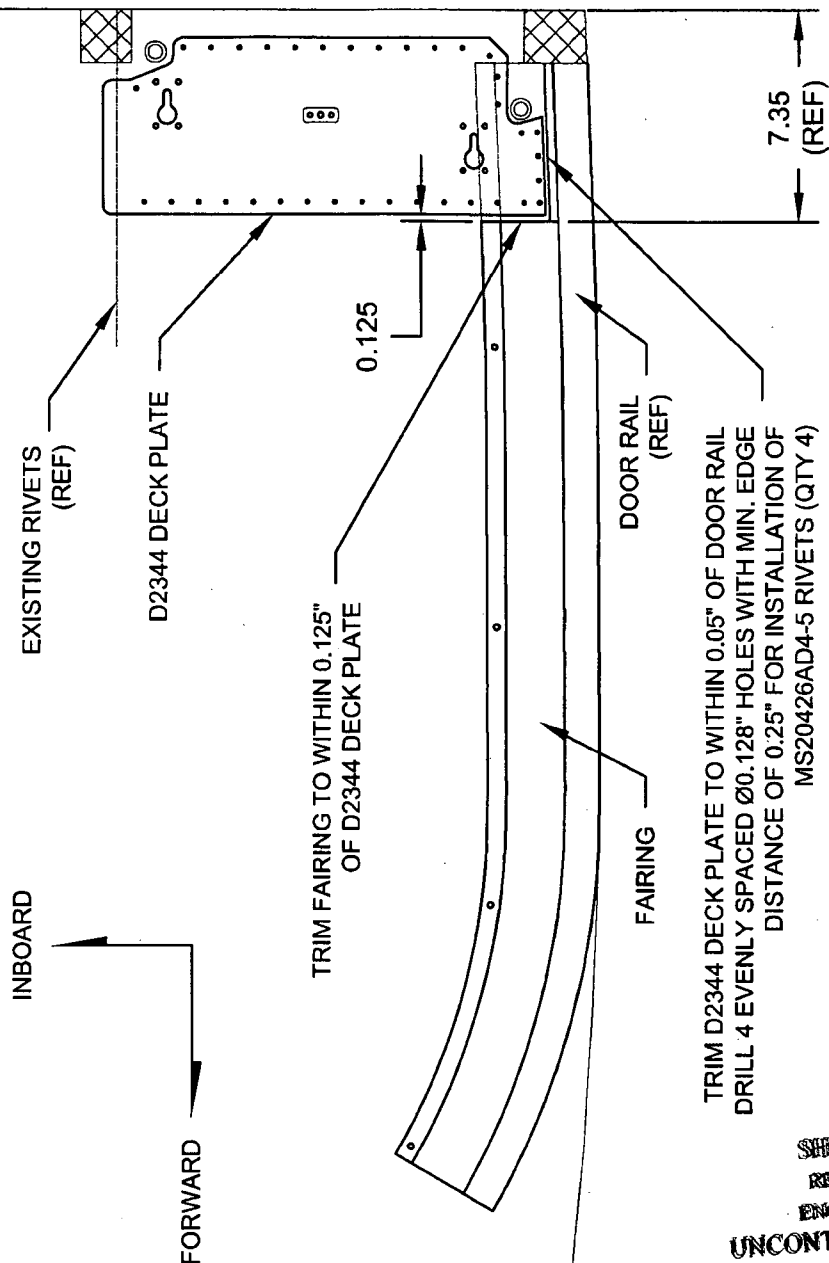


FIGURE 10

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